



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4881-042
Job Sheet 194054



Part No: D4881-042

Job Qty: 1 pcs

Part Name: 206A/B AFT Leg Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/25/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 3,4 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	5/6/19		0.00	0.78	Small Fab - 1		APR 26 2019 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	5/6/19		0.00	0.00	QC 5 - 10		APR 26 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Small Fab - 2 - B4B	1 pcs	5/6/19		0.00	0.78	Small Fab - 1 - B4B		APR 26 2019 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		

Plex 4/25/19 11:06 AM Dart.lajeunesse.marie

140	QC 5	1 pcs	5/6/19	0.00 0.00	Small Fab - 7 - B4B	AP 2019/04/29
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
						DAS 40 9-89
						APR 29 2019
180	Packaging 3-1 - Stock - B4B	1 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	ST 5/6
					Packaging 3 - 28 - B4B	APR 30 2019
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	1 pcs	5/6/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	APR 30 2019
					QC 21 - SA - 53	

Part Op 110 - (Small Fab) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND D4885-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP

DT9974 AS PER DWG.

120 - (QC5- Inspect part completeness to step on W/O)**130** - (Small Fab) 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER DWG USE DT9974 A/R BATCH: _____ 2- LASER ENGRAVE ASSEMBLY PART#, S/N

AS PER DWG QSI 44 6.8

140 - (QC5- Inspect part completeness to step on W/O)**180** - (Identify as per dwg & Stock Location: _____)**190** - (QC21- Final Inspection - Work Order Release)

009448

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	1 pcs (1 ea)	110-Small Fab - 1	5133248
D4885-2	End Fitting	1 pcs (1 ea)	110-Small Fab - 1	5128680
D4885-3	End Fitting	1 pcs (1 ea)	110-Small Fab - 1	5144469
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	110-Small Fab - 1	5141511
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	110-Small Fab - 1	5120513

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4881-1	1	11	0
	D4885-2	1	5	0
	D4885-3	1	3	0
	HL32PB5-12	4	83	0
	HL86-5	4	149	0

Part Specifications

Specifications could not be found.

Plex 4/25/19 11:06 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

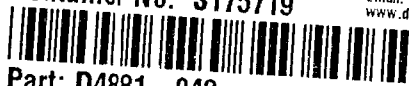
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S175719



Part: D4881-042

Job No: 194054

Serial No/Batch: S175719

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/26/19